

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005440**Date Inspected:** 07-Apr-2008**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 830**OSM Departure Time:** 1930**Location:** Muroran, Japan**CWI Name:** MaKhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

Witness Procedure Qualification Record (PQR) qualification test (SW-3): Caltrans Quality Assurance Inspector (QAI) representative Mr. Danny Reyes and Mr. Wai Pau, travel to Japan Steel Works (JSW) Muroran plant to witness an AWS D1.5 standard PQR qualification welding test. The number of PQR qualification welding test is SJ-2942-WP-4 (test plate SW-3). The PQR qualification test utilizing Flux Cored Arc Welding (FCAW) welding processes were conducted by welder Mr. Naoki Murai (05-00434) performed in the flat position (1G). The material used for the PQR qualification test specimens was reported by JSW Welding Engineer Mr. Takaaki Maruya as A148M-Gr.550-345 to ASTM A709M-Gr.345T (casting to plate) having a wall thickness measurement of 50mm. The weld joint design used butt joint, single-V-groove weld with 20mm x 75mm backing bar. The filler metal and shield gas used in the test for FCAW is Hoballoy wire TM-55, 1.6 diameter with 100% C02 made by Hobart Brothers, USA. The FCAW welding and parameters have been monitored and recorded by CWI inspectors Mr. MaKhmud Ashadi, Mr. Chung Kuan and JSW Welding Engineer Mr. Takaaki Maruya, and were also observed by Caltrans QAI. Filler weld passes (#18 to #37) were completed on this date and the PQR welding for this plate has been completed. Based on Caltrans QA observation, The PQR welding test was appeared to be in general compliance with the requirements of AWS D1.5 2002 and Caltrans contract document. The PQR will schedule to radiographic testing (RT) test.

Summary of Conversations:

As noted within the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer (858)697-6363, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

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for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
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Reviewed By:	Lanz, Joe	QA Reviewer
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